Work Order ID 56694

March 4, 2010 12:42:32 PM

Item ID: D3701-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Floor Doubler

Start Date: 3/22/10 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 3/22/10 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** [signature] **Date:** 10-3-09 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
Waterjet		0.00				FB 10-3-8			
FLOW CNC Waterjet	**Memo** 1-Cut as per Dwg D3701 ☐Dwg Rev: A ☐Prog Rev: A ☐2-Deburr if necessary								
6061 . 080						(2)			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC		0.00				HB 10-3-9			
Quality Control	**Memo**								
120	QC8- Inspect parts - second check	0.00							
QC		0.00				(HB)			
Quality Control	**Memo**								

Draw Nbr	Revision Nbr
D3701	Rev A

3/10/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 56694

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
Small Fab						2	0		
Small Fab	**Memo**	0.00							
Small Fab	1- Deburr if necessary 2- form as per dwg D3701								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC						2			10.03.17
Quality Control	**Memo**	0.00							
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish						X2	0		
Hand Finishing	**Memo**	0.00							

10/02/17

10/03/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 56694

March 4, 2010 12:42:38 PM

Item ID: D3701-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Floor Doubler

Start Date: 3/22/10 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 3/22/10 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00	BK 10-3-18			(2)			
170 Packaging Packaging	Identify as per dwg & Stock Location: 83	0.00							
	Memo	0.00				10/3/22 (2)			
180 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						10/03/24	
	Memo	0.00							

M 10-3-22 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

March 4, 2010 12:40:16 PM

Work Order ID: 56694

Parent Item: D3701-1

Parent Item Name: Floor Doubler

Start Date: 3/22/10 **Required Date:** 3/22/10

Comments: IPP Rev:A 08-01-30 new issue DD verifyed by:ec

Start Qty: 2.00 **Required Qty:** 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	134.6997	2.2200			
6061-T6 .080 Sheet												

FB 10-3-8

(2)

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	134.69967		
110630	35.0136		
112141	0.86727		
112763	0.19		
113438	98.6288		113438

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56694
Description: Floor Doubler	Part Number:	D3701-1
Inspection Dwg: D3701 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

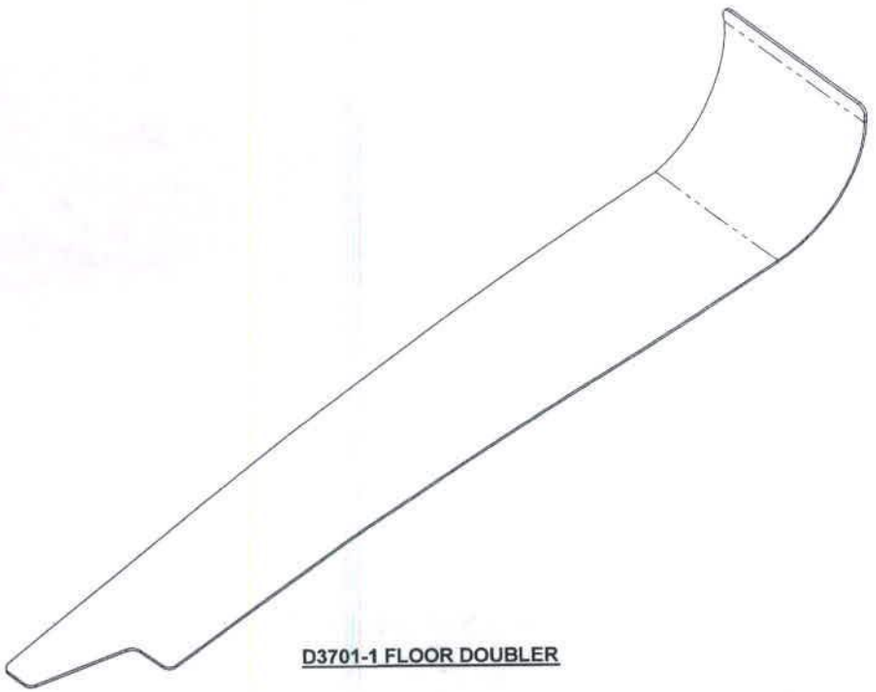
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.07	+/-0.030	1.071	*			
29.73	+/-0.030	29.73	*			
5.27	+/-0.030	5.27	*			
26.76	+/-0.030	26.75	*			
0.080	+/-0.010	.077	*			

Measured by:	EB
Date:	10-3-8

Audited by:	
Date:	10/03/02

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ	



D3701-1 FLOOR DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56694
BJ 10-3-04

RELEASED
09/04/08 AM

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3701-1" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.33 lbs
8) MANUFACTURE PART FROM "D3701-1F.DXF" FILE

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	08.04.30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3701	REV. A
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE FLOOR DOUBLER	SCALE NTS
DE APPR.			
DATE	08.04.30		

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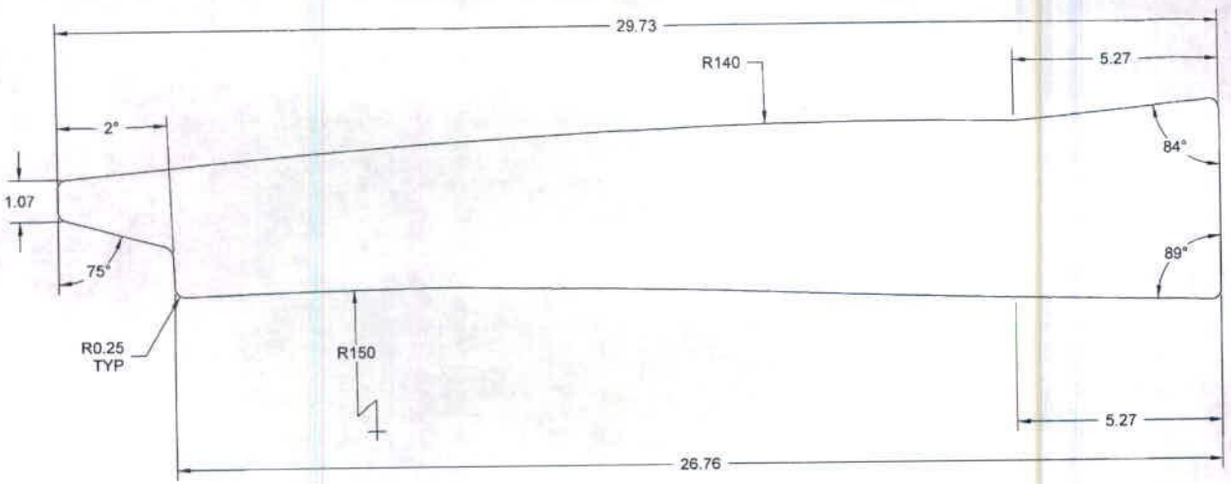
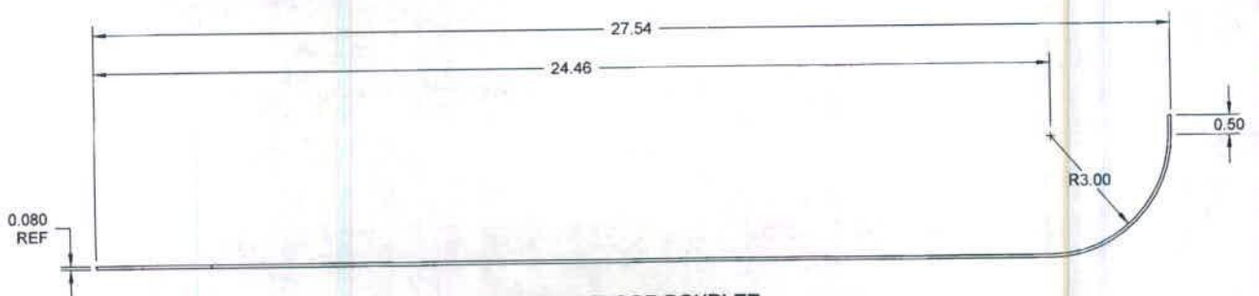


D3701-1F FLAT PATTERN



D3701-1 FLOOR DOUBLER
(MAKE FROM D3701-1F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO._____

RELEASED
09/04/08

w/o 36694

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3701 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		FLOOR DOUBLER NTS
DATE 08.04.30		

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